



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-141
Job Sheet 179614



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fts LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs	7/20/18	7/20/18	0.00	0.65	Skidtubes-2		
120	CNC Bend Skidtubes	1 pcs	7/20/18	7/20/18	0.52	0.65	CNC Bend Skidtube		
130	Skidtubes	1 pcs	7/20/18	7/20/18	0.00	0.65	Skidtubes-2		
140	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
150	Skidtubes	1 pcs	7/20/18	7/20/18	0.00	0.65	Skidtubes-2		
160	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC10		
170	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
180	HandFinish	1 pcs	7/20/18	7/20/18	0.00	0.04	HandFinish2		
190	Powdercoat	1 pcs	7/20/18	7/20/18	0.00	0.25	Powdercoat1		
200	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC3		
210	HandFinish	1 pcs	7/20/18	7/20/18	0.00	0.83	HandFinish4		
220	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
230	Packaging	1 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		
235	DC	1 pcs	7/20/18	7/20/18	0.00	0.00	DC		
240	QC21-FG	1 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES
Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215. Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 130834 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: 11:15 O.V.T: 320° FINISH: 11:45

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 18-12 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# 5080945

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

230 - Identify and pack for shipping as per PPPD205-634-141 Location: FG084

235 - Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS															
	Rework ☐	Scrap ☐	Use-as-is ☐	Suspected Unapproved ☐	Skid-tube ☐	Machining ☐	Thermoforming ☐	Large Fab ☐	Cross tube ☐	Small Fab ☐	Finishing ☐	Composite ☐	Water Jet ☐	Prod. Eng. Coord. ☐	Rec/Store/Packaging ☐	Supplier ☐	Engineering ☐	Quality ☐

Date: _____ Step #: _____ QTY Effective: _____ MRB (QS1042) Approval _____

Description Work Order _____ Completed By _____

Root Cause		Root Cause	
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE

Container No: S093667

Part: D205-634-141

Job No: 179614

Serial No/Batch: S093667

Revision: H/I

Inspector: _____

Exp Date: _____

Instructions: TC STC SH96-88 Issue 2, FAA STC SR00563NY 08/09/11, EASA ST _____

Pre	☐	Crushing	☐	Contamination	☐	Out of Sequence	☐	Positioned Wrong	☐
Bel	☐	Heat Treat	☐	Countersink	☐	Off-set	☐	Outside Dimensions	☐
Cer	☐	Wave/Twist in Tube	☐	Cut Too Short	☐	Mislabeled	☐	Over/Under tolerance	☐
Cra	☐	Marks/Chatter	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Part Incorrect	☐
Cri	☐		☐	Drill Holes	☐	Misaligned/off center	☐	Part Lost/Missing	☐
Cuffs	☐		☐		☐		☐	Part Moved	☐

QC / QA Coordinator	☐	Lead hand / Supervisor	☐
Approval	☐	Approval Verification	☐

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5002084
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	150-Skidtubes	50069014
D4202-1	Spacer	24 Ea (24 ea)	150-Skidtubes	5083526
AN3-5A	Bolt	2 Ea (2 ea)	210-HandFinish	5041106-1
AN4-45A	Bolt	8 Ea (8 ea)	210-HandFinish	5070194
D2570	Bushing	16 Ea (16 ea)	210-HandFinish	3x5084628 / 13x5094814
D2594-1	Plug	8 Ea (8 ea)	210-HandFinish	5054786
D2594-3	O-Ring	8 Ea (8 ea)	210-HandFinish	8097032 / 5084102
D2855	Cap	1 Ea (1 ea)	210-HandFinish	5066018
D4406-041	Fwd Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	5083397
D4406-043	Aft Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	5096758
MS21042-4	Nut	8 Ea (8 ea)	210-HandFinish	5089336
NAS1149D0332J	Washer	2 Ea (2 ea)	210-HandFinish	5035396-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	8	0
150-Skidtubes	D2576-3	1	34	0
	D4202-1	24	236	0
210-HandFinish	AN3-5A	2	194	0
	AN4-45A	8	144	0
	D2570	16	371	0
	D2594-1	8	337	0
	D2594-3	8	595	0
	D2855	1	83	0
	D4406-041	1	2	0
	D4406-043	1	3	0
	MS21042-4	8	41	0
	NAS1149D0332J	2	1,706	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 11:25 AM Dart.lajeunesse.marie

004716

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2579-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2555	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN980C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN980JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

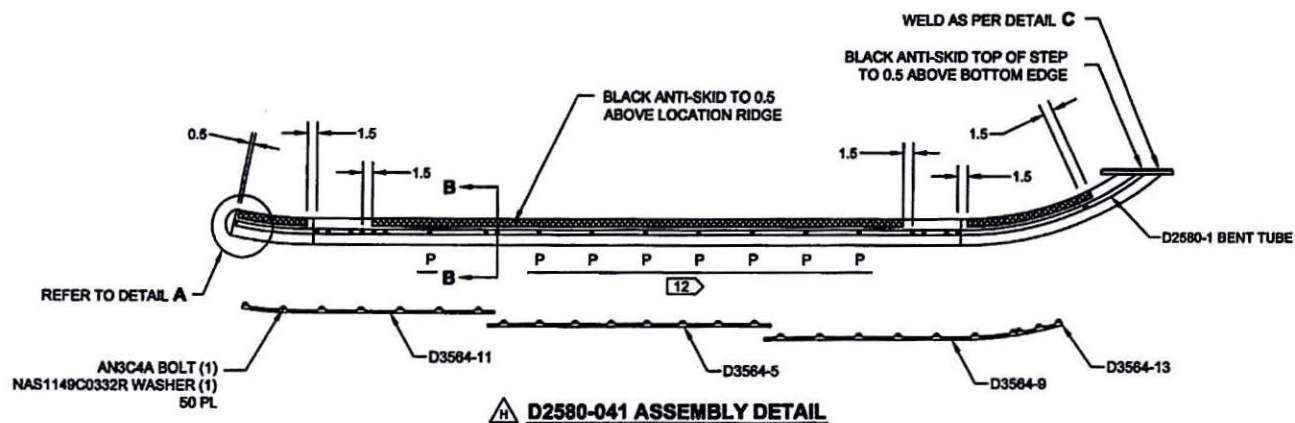
- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2500 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2500 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241A-291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (18 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2555 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE
WORK ORDER
NO. 1791614 U.S.

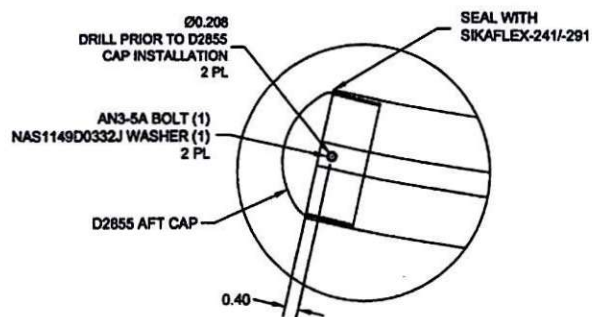
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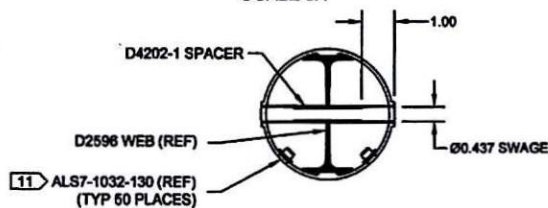
H	SHEET: PL DELETE D3566-1/-5/-13 GASKETS. WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 8124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	98.12.02
A	NEW ISSUE	DS	98.09.18
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 1 OF 9
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DETAIL A
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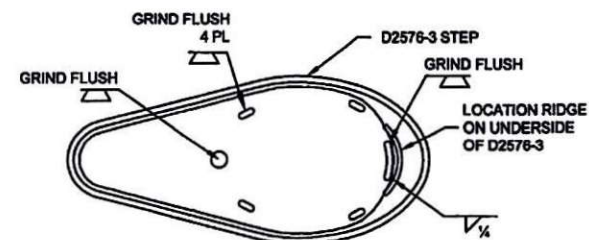


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

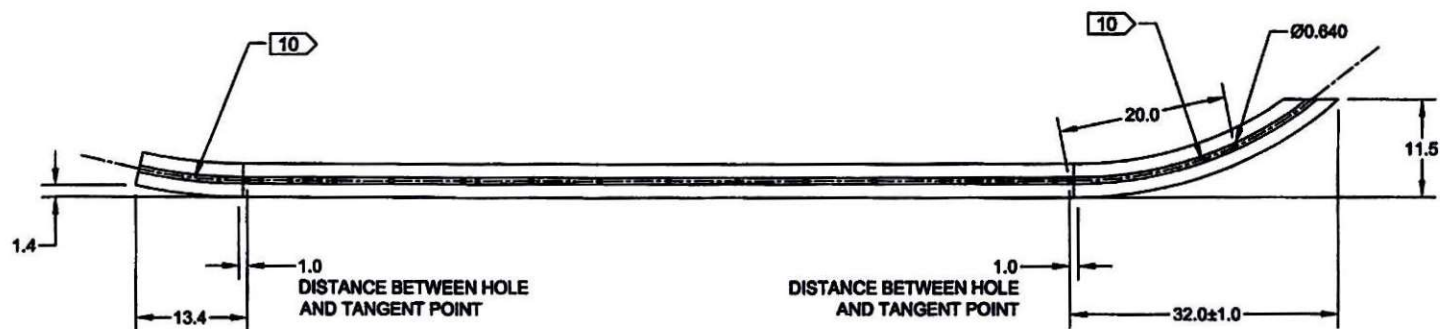
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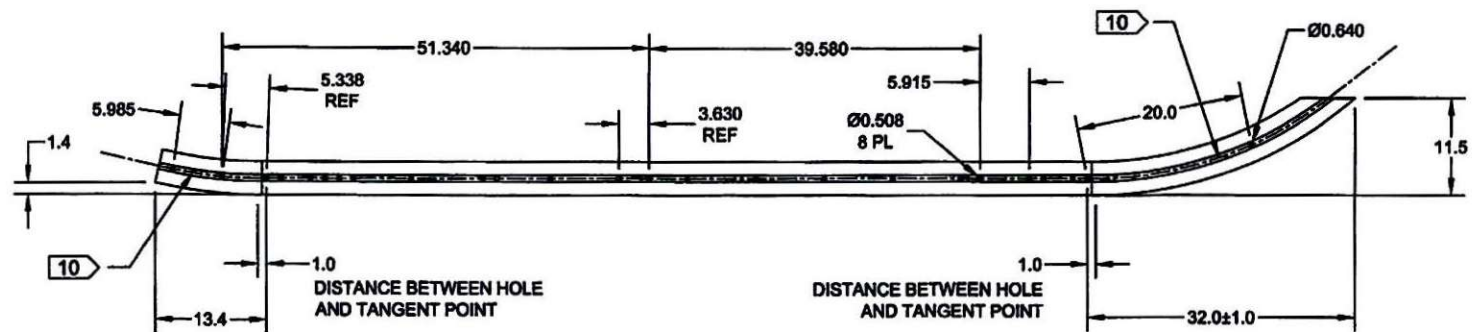
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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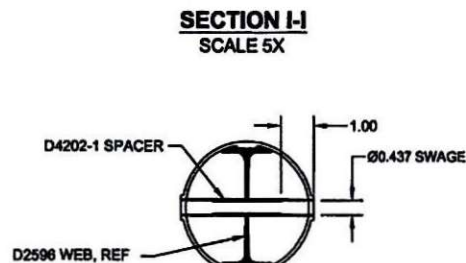
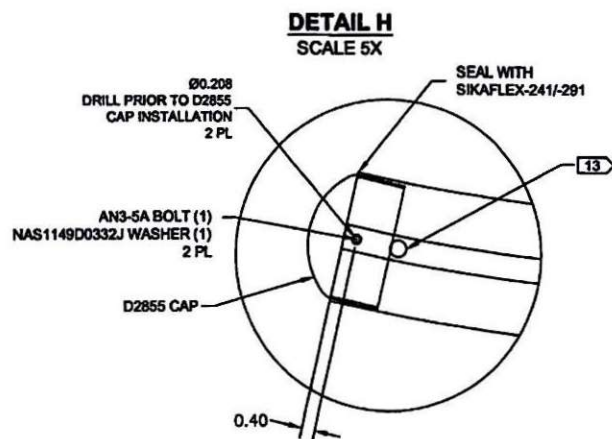
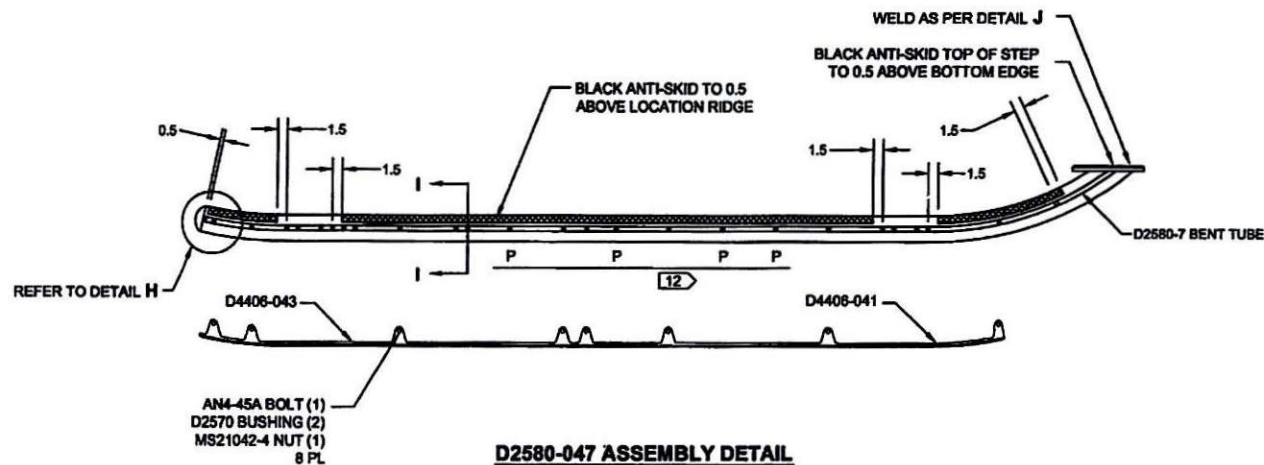


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

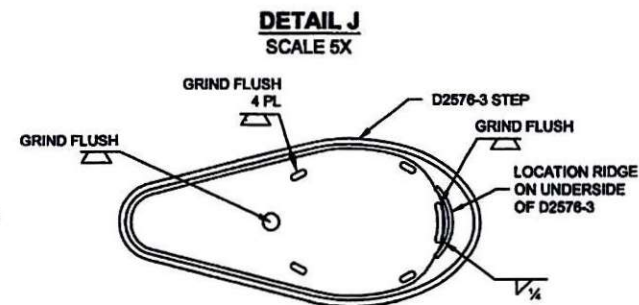
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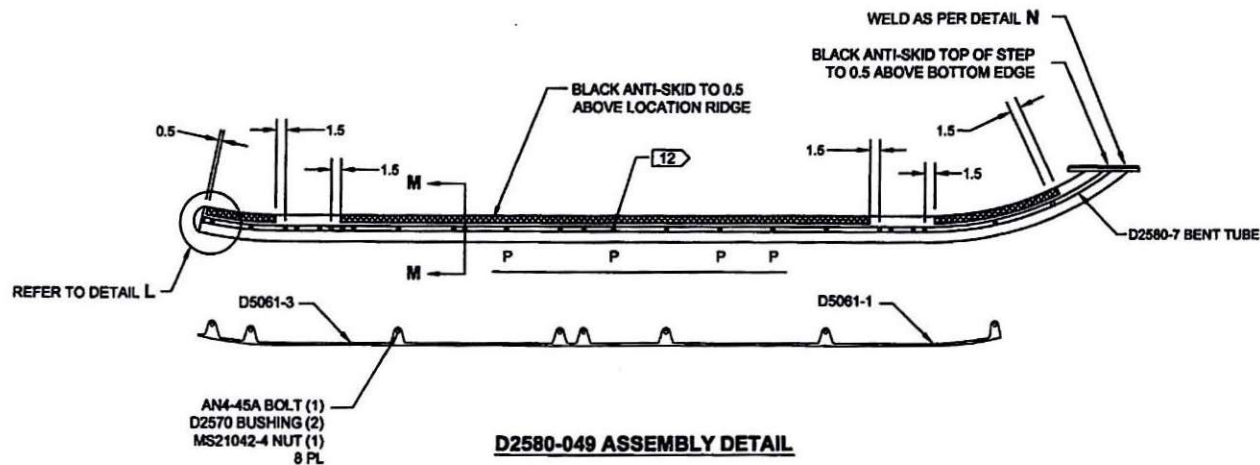
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



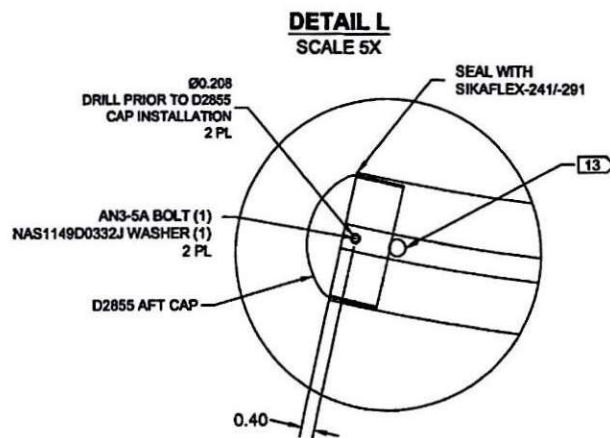
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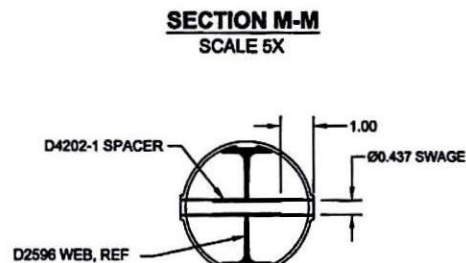
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D2580-049 ASSEMBLY DETAIL

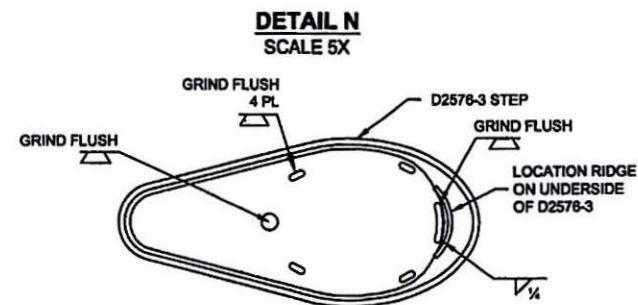


**DETAIL L
SCALE 5X**



**SECTION M-M
SCALE 5X**

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

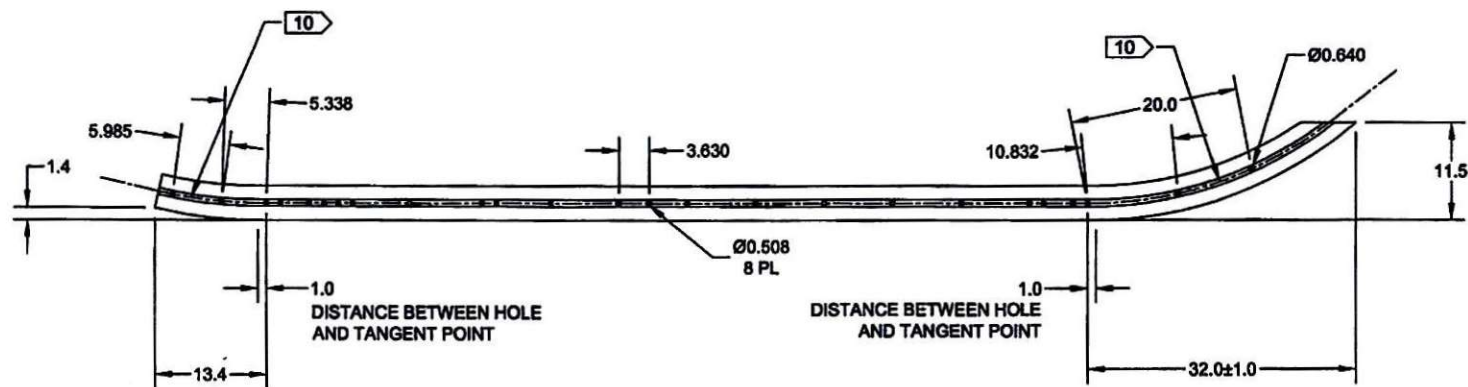


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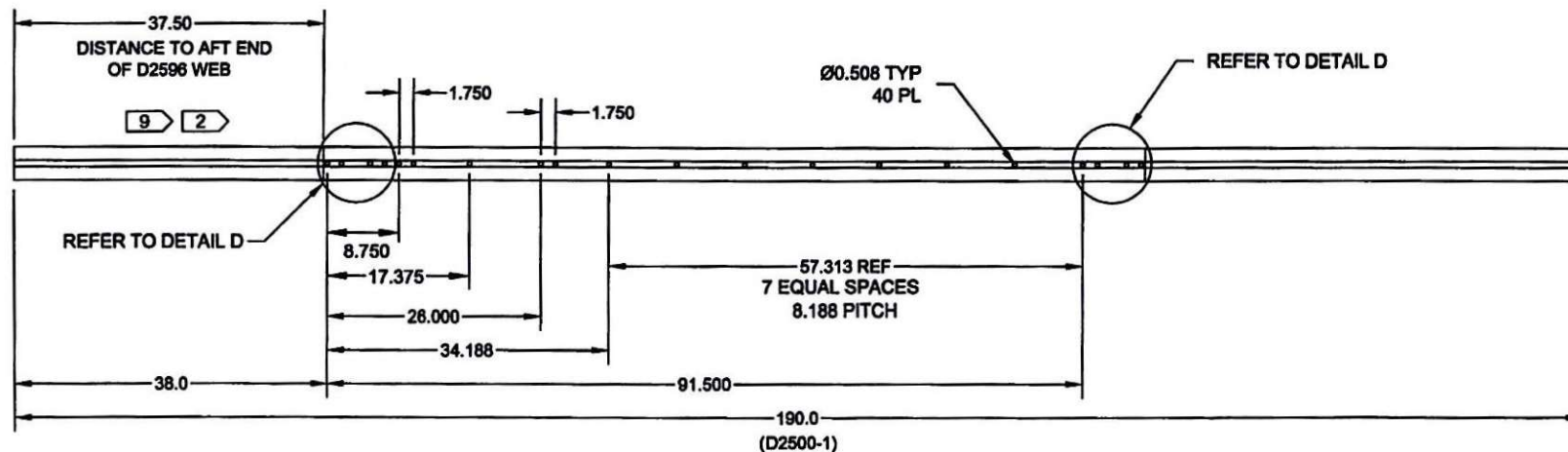


D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

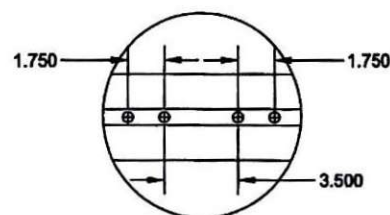
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